

Work Order ID 84787

May-23-12 9:23:02 AM

\*84787\*

Page 1

Item ID: DSK078

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: D2893-1 TURNING DETAIL

Start Date: 23/05/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00

\*100\*

Doosan

Doosan Lathe

Memo

Turn blank as per Folio FA081  
(4TH AXIS PLUG DT8492)

0.00

12/6/11

10

10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

12/6/11

10

10

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Quality Control

Memo

0.00

12-06-05

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84787

May-23-12 9:23:02 AM

**\*84787\***

Page 2

Item ID: DSK078

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: D2893-1 TURNING DETAIL

Start Date: 23/05/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: MAT 060

SL 12-06-05

(10)

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/6/6

12-06-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Checklist Print

23-12 9:23:06 AM

Work Order ID: 84787

\*84787\*

Parent Item: DSK078

\*DSK078\*

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-005

Manufactured

No

Each

24.0000

10

\*D6104-005\*

\*\*

Round Billet, 17-4

121611

## Location

## Loc Qty

## Loc Code

MAT043

22

81922

10

83686

12

MAT047

2

80114

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Ins

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84787
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b>	DSK078
<b>Inspection Dwg:</b> DSK078 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article      ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.7078	2.7075	2.708	2.7082	2.7079
B	4.946	4.966		4.956	4.956	4.956	4.956	4.956
C	3.064	3.084		3.074	3.074	3.073	3.073	3.074
D	0.718	0.738		.725	.728	.728	.728	.728
E	0.090	0.110		.103	.100	.101	.100	.101
F	2.934	2.954		2.943	2.943	2.943	2.944	2.943
G	2.166	2.186		2.175	2.175	2.175	2.175	2.175
H	3.890	3.910		3.900	3.901	3.900	3.900	3.900
I	0.914	0.934		.927	.925	.925	.925	.925
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

**Measured by:** S.J. / G.K.      **Date:** 12/6/11

**Audited by:** J.      **Date:** 12-06-05

**Prototype Approval:**      **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	J.M.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	84787
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

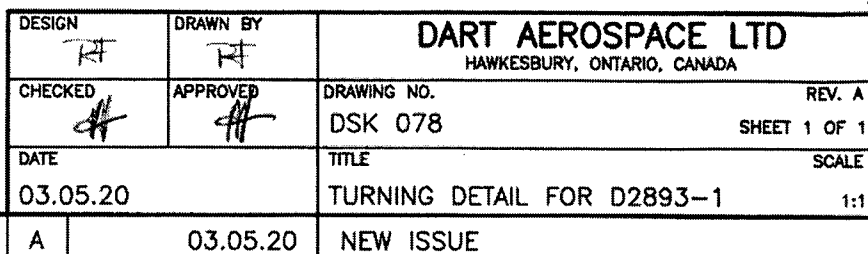
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.7083	2.7085	2.7084	2.7087	2.7088
B	4.946	4.966		4.956	4.956	4.956	4.956	4.956
C	3.064	3.084		3.074	3.074	3.074	3.074	3.073
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.101	.100	.100	.101
F	2.934	2.954		2.943	2.944	2.943	2.943	2.944
G	2.166	2.186		2.175	2.175	2.175	2.175	2.175
H	3.890	3.910		3.900	3.899	3.901	3.900	3.900
I	0.914	0.934		.926	.925	.925	.923	.923
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: *SL / cmf* Date: 12/6/11

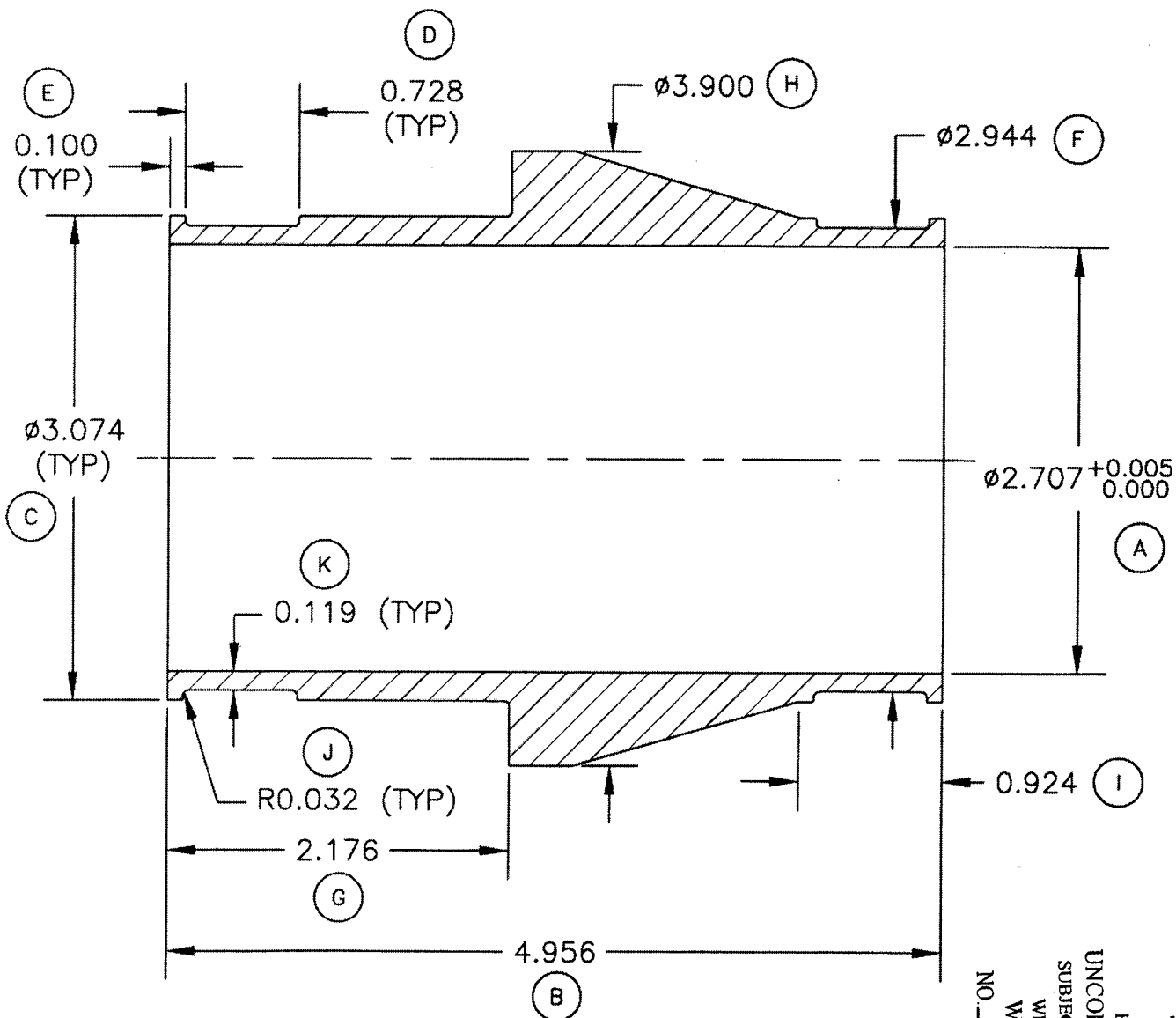
Audited by: *SL* Date: 12-06-05

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>



RELE D  
03.07.01



D2893-1 TURNING DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 24384  
M13

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries